

From:

Adrian Melendez [adrian@petroindustrial.us]

Sent:

4/15/2021 1:30:37 PM

To:

Merlin Figueira [mef@vtti.com]; 'Matthias A. Clarke' [Matthias.Clarke@viwapa.vi]

CC:

Hanief Aziz [Hanief.Aziz@viwapa.vi]; Larry J. Mondy [Larry.Mondy@viwapa.vi]; Sebastian Moretti [srm@Vitol.com];

Charlotte Pratt Horowitz [cap@Vitol.com]; Andrew Canning [Andrew.Canning@optis.co.uk]; Chad Persaud

[chad@petroindustrial.us]

Subject:

3" SS Vent line project

Attachments: WPS-Comb-SMAW-GTAW.pdf; WPS-GTAW (Tig).pdf; WPS-SMAW (Stick).pdf; WPS-SMAW (Structural).pdf; WPQ-All

Petro Welders-WAPA-IPOS.pdf

External Email: Do not open links/attachments from untrusted senders (Sender appears to be adrian@petroindustrial.us)

Good morning Team,

Please find Petro's welding procedures and welder's quals for your review.

Thank you,

Adrian Melendez Project Manager (956) 605-4142



	Petro Industrial Solutions, LLC Page 1 of 3 PO Box 26303 Christiansted, Vi 00824
	ING PROCEDURE SPECIFICATIONS (WPS) PISL-COMB-P1 tion IX, ASME Boiler & Pressure Vessel Code)
Company Name: Petro Industrial Solutions, LLC Welding Procedure No. PISL-COMB-P1	By: Procedure Creator Date Supporting PQR No. PISL-COMB-P1-PQR
Rev. No. 0 Date Welding Process (es) SMAW/GTAW	Type (s) Manual
	(Automatic, Manual, Machine, or Semi-Auto)
JOINTS Joint Design Backing (Yes) (NO) X Backing Material (Type) N/A (Refer to backing & retainers.) Metal Nonfusing Nonmetallic Other	letal
Joint Design Single U - Groove Backing (Yes) (NO) X Backing Material (Type) N/A (Refer to backing & retainers.)	A SALAGA CA - A HARAM
Joint Design Branch Connection Backing (Yes) (NO) X Backing Material (Type) N/A (Refer to backing & retelners.)	
Joint Design <u>Groove Connection</u> Backing (Yes) (NO) X Backing Material (Type) N(A (Refer to backing & retainers.)	The state of the s
Joint Design Fillet Weld Backing (Yes) (NO) X Backing Material (Type) N/A (Refer to backing & retainers.) (Refer to backing & retainers.)	ALL JOINTS

		Potro Industrial S PG Box 2 Christiansted	6303	Page 2 of 3
	lva-tivosiyamaanaanaassamaanaanaanaanaa	ING PROCEDURE SI		(WPS) PISL-COMB-P1
IOINTS (CONTD) Ioint Design Backing (Yes)(NO)	Socket Weld X	ction IX, ASME Boiler & I DETAILS (see belo		
Sacking Material (Type)	N/A			
Metal	(Refer to backing & retainers.) Nonfusing N	Retail		
Nonmetaliic	Other			
	Hara Cara Robert	OR 1995 SALT 1995/AGES		
	× 100 × 100	s do on edrome tracinhess Parechever is salaulea, ur Al Courald by trachabild a	KLESS OF SERVISE	
		raxordwieta / 14 m belæ	H VKODVO-	
RECONNECTED	D WELOWG BAJEKELONS FOR	SOCKET INGLE WE COMPE	HENTS OTHER THAN FLANGES	
Přebech ASBS BANK N	FELD: FAICE, AURO 854	CX GREIS TWO	OKET CHILDING IS MICE	
L Var	t)— []_	· - + F-	-14/77	
	1 4	-vt	Lyon Control	
			W- APPROXIMATELY YIE of DEFCIAL WELFIELD	
E EHE PASSINGATA	202 FACE TE HE EX EXT TIGHT		SS OTHERWISE REQUIRED BY -E-1889CATION DOCUMENTIS:	
	RECOMMENDED WELDING	DIVERSIONS FOR FLANGE	5.	
Sase Metals P-No. 1	Group No. 1	to P.No	I Group No.	2
OR			***************************************	
Specification Ty to specification type and		Spec SA 53/105/106 Spec SA 53/105/106	/134/135/176/179/161/192/2 /134/135/178/179/181/192/2	10/211/234/266/333/334/350/372 10/211/234/266/333/334/350/372
OR Chem, Analysis and Medito Chem, Analysis and Analysis and Analysis and Analysis and Analysis			N/A N/A	
hickness Range: Base Metal:	300000000000000000000000000000000000000	**************************************	0.0625" to 0.436	N
Pipe Dia. Renge			1" OD ta Unlimit	
iller Metals			Root & Fill	
Spec. No. (SFA) AWS No. (CLASS)		+4-,	A5.18 / A5.1	
F-No.			ER70S-3* / E-7018* F-8 / F-4	
A-No.		***************************************	A-1 / A-1	
Size of Filler Metal	**************************************		3/32", 1/8"	
Filler Metal Form Deposited Wetd Metal		Bar	e Rod / Electrode (Core Win	2
Thickness Range (Groove)			0.436" max / 0.436" max 0.0625" to 0.436"	······································
Thickness Range (Fillet)	emaca walan anama a anama		All	
Electrode-Flux (class)			N/A	
Flux Trade Name	- Univ		N/A N/A	
Consumable Insert				

Petro Industrial Solutions, LLC PO Box 26300 Christiansted, Vt 00824							C 	Page 3 of 3		
	والمعالية والكر						t in the s			
WWW.TWW.		***************************************	WELDIN	G PROCED	URE SPEC	CIFICATIONS		(WPS) PISL-COMB-P1		
err beautyland begr			(See			& Pressure Ves	sel Code)			
POSITIONS		- A	LL	Total Control of the	HEAT TRE	ATMENT				
Position (s)	CERTIFIER COORDESSESSESSESSESSESSESSESSESSESSESSESSESS			Temperatu	mineral transfer of Santa was about the		******	N/A		
	gression: U		Up	Time Range	9			N/A		
Position (s)	of Fillet	N	/A		,					
	- Aire			GAS		rcent Compos				
PREHEAT				1	Gas (s)	(Mixte	ure)	Flow Rate		
Preheat Ten		CARROLL AND A CARROLL STATES AND ADDRESS.	Min							
Interpass Te	emp.	50°F Min /	500°F Max	Standing	Argon	100	···	15-40		
(Continuo	us or special l	heating is not	required)	Trailing	N/A	N//	*****	N/A		
				Backing	N/A	N/A	Α	N/A		
TI FORMIOA					19,-1-1	The state of	promise the second			
	L CHARACTI				Observatoria	. (OTAMA / D.	/011111			
Current AC		-	C	Polarity		t (GTAW) / Rev	verse (SMAVV)			
Amps (Rang	je)	566	Table	Volts (Rang	30)	See Table	-			
Tungeton El	ectrode Size	and Tune			20/	Thoriated 0.062	W 4- 0 003" /	Carintadi		
ungaten E	ecu ode 312e	and type	January III		276 (P	ure Tugnsten, 2% T	horisted 2% Ceri	Centred)		
Morte of M	etal Transfer	for GMAW			V	and raginature 220 i	N/A	area, ener,		
INCOS OF IN	TOWN THEIRDIGE	IDI GMATT	***************************************			(Spray arc. sho	ort circuiting arc, e	ic)		
Hectrode W	fire feed spec	enge h				Coping and and	N/A			
- mondo vi	1000 opoc	a vango	months and the second	Pettoritaini and a second	Milaterial Transmission					
TECHNIQUE			-				***************************************			
String or We						Either				
	as Cup Size	<u> </u>		(i)_iotarentimentum		1/4" to 1/2	2"	**************************************		
	terpass Clea	nina	***************************************		Mechan	ical only (joint s		or to welding)		
			- IPWest IIIIII		HILLIA THE STATE OF THE STATE O			The second secon		
Method of b	ack gouging				Mechanical c	or Thermal (whe	en required by	joint configuration)		
Dacillation						,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	N/A	, and a state of		
Contact Tub	e to Work Di	stance					N/A			
Multiple or S	Single Pass (per side)					Both			
Multiple or S	Single Electro	des				5	Single			
Travel Spee	d (RANGE)						e Table			
Peening						Not	Allowed			
Other							N/A			
		······································	WATER THE PARTY OF							
				**************************************		DING TECHNIC	######################################	Atomorphism of the state of the		
			asses may		n stonger be: rent	ads or weave b	eaos as requir	e 0.		
		1		Cur	AMP		Travel			
Weld	Electrode	Weld	Filler	Туре	Renge	Volts Range	Speed	Other (e.g., Remarks, Comments)		
Process		Layer	Diameter	Polar.			Speed IPM/RPM	- marting waterings		
	The state of the s				Low - High					
Stringer	SMAW	FIII	3/32"	Reverse	70-100	20-24	As Required	Holding Oven (50°F to 250°F) for Lo		
	CHIPTY	1 111	1/8"	DC (EP)	100-175	16-28	ve vednied	Hydrogen Electrodes		
Beads			1/16"	Straight DC	50-140	10-18				
GTAW		E A A		Straight DC	50-220	10-18	As Required	No Comments		
GTAW weld with	GTAW	As required		(EN)	and the state of the late of	THE RESERVE OF THE PARTY OF THE	I w madanaa	***************************************		
GTAW	GTAW	As required	3/32" 1/8"	(EN)	50-300	10-18 Company:		Petto Industrial Solutions, LLC		

Doint Design				o Industrial Sol PO Box 2631 Irristiansted, VI	03		Page 1 of 2
(See Section IX, ASNE Boller & Pressure Vessel Code) Record of Actual Conditions Used to Weld Test Coupon Company Name: Petro Industrial Solutions, LLC Procedure Qualification Record No. WPS No. WPS No. PISL-COMB-P1-PQR PISL-COMB-P1 GTAWSMAW Types (Menual, Automatic, Semi-Auto) MANUAL WELDING Joint Design Backing (Yes) Joint Design Backing (Yes) Material (Type) Material (Type) Material Spec. Type or Grade Gr. B Time N/A Other N/A Other N/A Other N/A FILLER METALS 1 2 Trailing Argon 100% 30 CPH N/A FILLER METALS 1 1 2 Trailing N/A		Aug E Je					
Company Name: Petro Industrial Solutions, LLC Procedure Qualification Record No. WP'S No. WP'S No. Welding Process (es) Types (Manual, Automatic, Semi-Auto) Joint Design Backing (Yes) Metal (Refer to bescript a retainers) Metal Normetallic Normetallic Normetallic SA-106 Temperarature Normetallic Normetallic Normetallic Normetallic POSTWELD HEAT TREATMENT Temperarature N/A Normetallic Normetalli		THE RESERVE AND ADDRESS OF THE PARTY OF THE		SECURIOR SEC			COMB-P1-PQR
Company Name: Petro Industrial Solutions, LLC Procedure Qualification Record No. PISL-COMB-P1-PCR Date Date of coupon for PQR PPROCEDURE QUARTER PISL-COMB-P1		,				,	
Joint Design Single V - Groove Racking (Yee) N/A f = 1/16" r = 1/8" a = 35"	Procedure Qualification Red WPS No. Welding Process (es)	atrial Solutions, I cord No.	LLC PISL-COMB- PISL-COMB- GTAW/SMAV	P1-PQR P1 V		,	r PQR
Backing (Yee)	JOINTS			- myriain		THE THE PERSON NAMED IN TH	
Metal Nonmetallic	Backing (Yes)(NO)	X	/ - Groove		f≈ 1/16"		
Material Spec. SA-106 Temperarature N/A Type or Grade Gr. B Time N/A P-No. 1 to P-No. 0.432" Diameter of Test Coupon Diameter of Test Coupon Other 6 N/A Other GAS Percent Composition Filler METALS 1 2 Trailing N/A N/A N/A SFA Specification 5.1 5.18 Backing N/A N/A N/A AWS Classification 5.1 5.18 Backing N/A N/A N/A Filler Metal Analysis A-No. 1 1 Current Direct Current (DC) Other N/A N/A N/A N/A N/A N/A N/A 1-2-25 Torailing (TAWY70-85 (SMAW) Volts (EN) / Reverse (EP) 10-10-100 (GTAWY70-85 (SMAW) Volts (EN) / Reverse (EP) 10-10	Metal		retainers.) Nonfusing Met	a l			
Material Spec. SA-106 Temperarature N/A Type or Grade Gr. B Time N/A P-No. 1 to P-No. 0.432" Diameter of Test Coupon Diameter of Test Coupon Other 6 N/A Other GAS Percent Composition Filler METALS 1 2 Trailing N/A N/A N/A SFA Specification 5.1 5.18 Backing N/A N/A N/A AWS Classification 5.1 5.18 Backing N/A N/A N/A Filler Metal Analysis A-No. 1 1 Current Direct Current (DC) Other N/A N/A N/A N/A N/A N/A N/A 1-2-25 Torailing (TAWY70-85 (SMAW) Volts (EN) / Reverse (EP) 10-10-100 (GTAWY70-85 (SMAW) Volts (EN) / Reverse (EP) 10-10	BASE METALS			IPOSTWELD	HEAT TREA	TMENT	HART THE STANFART AND THE
Type or Grade Gr. B Time N/A P-No. 1 to P-No. 1 Other N/A Thickness of Test Coupon Diameter of Test Coupon Other 6 Percent Composition Other N/A Percent Composition Fill ER METALS 1 2 Trailing N/A		SA	-106			1	N/A
Diameter of Test Coupon		G	ir. B				
Diameter of Test Coupon Other		to P-No.	1	Other			N/A
Other							
GAS			6				
Shielding	Other	N/A	1010		THE PARTY OF THE P	and the state of t	
Shielding Argon 100% 30 CFH			40750	GAS	4 9 9		
FILLER METALS		way, and the same of the same		DE I-LUI			The state of the s
SFA Specification 5.1 5.18 Backing N/A N/A N/A AWS Classification E-7018 ER70S-3 Electrical Characteristics Current Direct Current (DC) Size of Filler Metal 1/8" 1/8" Polarity Straight (EN) / Reverse (EP) Other N/A N/A N/A Amps. 110-130(GTAWy70-85 (SMAW) Volts 12-25 N/A N/A N/A Tungsten Electrode Size 0.062" 2% Thoriated Deposited Weld Metal 0.125" 0.307" Other N/A POSITION 6G Travel Speed 3 IPM Weld Progression (Uphill, Downhill) Uphill String or Weave Bead String Other N/A No Multipass PREHEAT Single or Multipass Electrodes Single Preheat Temp. Ambient (>50°F) Other N/A	FILLED METALS		A		With the control of t	and the second s	
AWS Classification E-7018 ER70S-3 Electrical Characteristics		Company of the Conference of t					
Filler Metal Analysis A-No. 1			The state of the s			The second secon	I N/A
Size of Filler Metal		7/0	ER705-3		aracteristics		weet (DC)
Other N/A		Contraction of the contraction o	1/9"		-		
N/A N/A Tungsten Electrode Size 0.062" 2% Thoriated					440 420/CTAM		
Deposited Weld Metal 0.125" 0.307" Other N/A	Out-Ci				trode Size	O OF	2% Thoristed
Position of Groove 6G Travel Speed 3 IPM Weld Progression (Uphill, Downhill) Uphill String or Weave Bead String Other N/A Oscillation No Multipass or Single Pass (per side) Multipass PREHEAT Single or Multipass Electrodes Single Preheat Temp. Ambient (>50°F) Other N/A Interpass Temp. 500°F max N/A	Deposited Weld Metal		(III)			Programme and the second secon	AND THE RESERVE OF THE PARTY OF
Position of Groove 6G Travel Speed 3 IPM Weld Progression (Uphill, Downhill) Uphill String or Weave Bead String Other N/A Oscillation No Multipass or Single Pass (per side) Multipass PREHEAT Single or Multipass Electrodes Single Preheat Temp. Ambient (>50°F) Other N/A Interpass Temp. 500°F max N/A	POSITION		D=344	TECHNIQUE		We do not	
Weld Progression (Uphill, Downhill) Other N/A Oscillation Multipass or Single Pass (per side) PREHEAT Preheat Temp. Interpass Temp. String or Weave Bead Oscillation No Multipass or Single Pass (per side) Multipass Single or Multipass Electrodes Other N/A Other N/A	Position of Groove		3G				3 IPM
Other N/A Oscillation No Multipass or Single Pass (per side) Multipass PREHEAT Single or Multipass Electrodes Single Preheat Temp. Ambient (>50°F) Other N/A Interpass Temp. 500°F max	Weld Progression (Uphill, Downhill)				ve Bead	-	
PREHEAT Single or Multipass Electrodes Single Preheat Temp. Ambient (>50°F) Other N/A Interpass Temp. 500°F max	Other		V/A				
PREHEAT Single or Multipass Electrodes Single Preheat Temp. Ambient (>50°F) Other N/A Interpass Temp. 500°F max				Multipass or S	Single Pass (ı	per side)	
Preheat Temp. Ambient (>50°F) Other N/A Interpass Temp. 500°F max	PREHEAT						
	Preheat Temp.						
Other N/A	Interpass Temp.						
	Other		WA				

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/				THE RESERVE OF THE PERSON NAMED IN COLUMN	UALIFICATI	THE RESERVE OF THE PERSON NAMED IN	Market Control of the	R) PISL-COMB-P1-PQR
					ME Boiler & F			
		ministra	Record		nditions Used		st Coupon	
	7	1	-	1	ENSILE TE			
Specimen No.	Width (In)	Thickness (in)	Area (In²)		mate .oad (lb)	Tensile	nate Strenght si)	Type of Fallure & Location
T-01	0.753	0.432	0.325	21,	,258		350	Ductile/Base Metal
T-02	0.751	0.432	0.324	20	938	64	540	Ductile/Base Metal
		0.102	0.027	20,	000	01,	040	Ductile/Dase Micial
	Annual Control			GUID	ED - BEND	TERTE		
_	Type	and Figure N	lo.	GUID	UN20 - USNU	16313	Res	sult
		t Bend QW 46					ACCE	
		t Bend QW 46					ACCE	
		e Bend QW 46					ACCE	
		e Bend QW 46					ACCE	
				TOU	GHNESS T	ESTS		
Specimen	Notch		Test	Impact	Latera	-	- 313-	Drop Weight
No.	Location	Notch Type	Temp.	Values	% Shear	Mils	Break	No Break
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Result-Satisfo	actory: Yes	N/A	No		ET-WELDS		al: Yes/No	N/A
MacroRres	sult					N/A		
				C	THER TES			
					A N ABOVE A D SWADE			
Type of Test Deposited A		mum minutes			MINISTER AND	N/A		######################################
Jeposited A Other	Halysis					N/A N/A		
	***************************************	********************	***********	*******		***************************************		
Welder's Na			iel Martine				Stamp No	6941
ests condu	cted by:			INI Co	orp.			
Mechanical "	Test Conduc	cted by:		Gilberto	Martinez		Test No.	PISL-052418-02
Ve Certify tha	t the stateme		ਦੇ are correct ode.		e test welds v		d, welded, and t	tested in accordance with the
						Сотралу:		o Industrial Solutions, LLC
Date:		24-May-2018				Ву:	M	let
							- Allen	7

	Petro Industrial Sc PO Box 25. Christiansted, V	303	Page 1 of 3
	NG PROCEDUR⊞ SPI Ion IX, ASME Boiler & Pre	Birth Secretary	(WPS) PISL-GTAW-SS
Company Name: Petro Industrial Solutions, LLC Welding Procedure No. PISL-GTAW-SS	By: Proce	edure Creator Supporting PQR No	. PISL-GTAW-SS-PQR
Rev. No. 0 Date Welding Process (es) GTAW	Type (s)	Manual	
BARTER CONTROL		(Automatic, Manual, Machine	Or Sami-Auto)
JOINTS Joint Design Single V - Groove Backing (Yes) (NO) X Backing Material (Type) N/A (Refer to backing & reteiners.) Metal Nonfusing Metal Nonmetallic Other	etal	DETAILS	1 - 20 - 20 - 20 - 20 - 20 - 20 - 20 - 2
Joint Design Single U - Groove Backing (Yes) (NO) X Backing Material (Type) N/A (Refer to backing & retainers.) (Refer to backing & retainers.)		- t	= Whit shift for the or 1 1885 - the or 10 1885 - the or 10 1885 - 10 1885 - 110 or 120 or 131 Kinner Less the or 1885
Joint Design Backing (Yes) (NO) X Backing Material (Type) N/A (Refer to backing & retainers.) (Refer to backing & retainers.)		10 m 5	17 1 5 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Joint Design Groove Connection Backing (Yes) (NO) X Backing Material (Type) N/A (Refer to backing & relainers.) (Refer to backing & relainers.)		\\ \tag{\chi_1}	## 10 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0
Joint Design Backing (Yes) (NO) X Backing Material (Type) N/A (Refer to backing & retainers.) (Refer to backing & retainers.)			ALL JOINTS

			P(ustrat So Dec 283 ansted, V		Page 2 of 3
0,00,753					CIFICATIONS Seure Vessel Code)	(WPS) PISL-GTAW-SS
JOINTS (CONT'D) Joint Design Backing (Yes) Backing Material (Type)	(NO) X	it Weld		ETAILS se below)		
Metal Norma	(Refer to beckin	g & retainers.) Nonfusing Me Other	etal			
	**	# AON 63	E PRE VALL DAY O TA OF THE PRICE SAY CHAPED BY THE	CANESS OF STATES	S OTHERWISE EXXUSTERS	
	D 840× MENT THE OTHER OT	EVBLOASFORS			5 C (12 ME R 3 MAN N 1 ANG)	23
8+7 8	7		**************************************	h. K.	APPROXIMATELY	NT 2G
1 100A × 100A 1	OF THE THICKLES OF T BRICATION DOCUMENT IN TWOCHEVETTS SAN ALFREWALT THICKNES BESCHWEN	S: LEA VAESSOT	452999 92K998.8*	ACD SV 1448 8		1
Base Metals P-No.	8 Group No.	1,2,3,4	to P-No.	8	Group No.	1,2,3,4
Specific to specification	OR cation Type and grade type and grade		SA167/	182/213/240	//249/269/312/358/37	6/403/409/479/666.TP316,T316L 6/403/409/479/666.TP316.T316L
Of Chem. Analysis s			W-11/2/2/10		N/A	
to Chem Analysis Thickness Range: Base Metal: Pipe Dia, Range:	and Mech. Prop.				0.0625" to 0. 1" OD to Uni	
Filler Metals					Root & Fill	
Spec. No. (9 		A6.9 ERXXX	
F-No.					F-6	
A-No. Size of Filler Met	al				A-8 1/16", 3/32", 1/6"	
Filler Metal Forn	n				Bare Rod	· · · · · · · · · · · · · · · · · · ·
Deposited Weld M Thickness Range (Gr		····	·····	•••••	0.436" max 0.0625" to 0.436"	
Thickness Range (F	Wet)				All	
Electrode-Flux (cla Flux Trade Nam					N/A N/A	
Consumable Inse	T-7000		**********		N/A	
Other			SANTHUR DE CONTROL DE	Max	mum Misalignment=	3/32

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				Chr	PO Box 2 istialisted					
							# # # # # # # # # # # # # # # # # # #			
			WELDIN	G PROCED	URE SPEC	IFICATIONS		(WPS) PISL-GTAW-SS		
			(See	****************	**********************	& Pressure Ves	sel Code)			
POSITIONS		A	LL	POSTWELD	************	ATMENT				
Position (s)				Temperatui	*********	-6		N/A		
	ogression: Up	4404058	Up	Time Range)	·		NA		
Position (s)	of Fillet	l N	/A	ļ			·····			
				GAS		rcent Composi	######################################			
PREHEAT					Gas (s)	(Mixtu	ure)	Flow Rate		
Preheat Ter		Harriston and the second	Min							
Interpass T	emp.	N	I/A	Standing	Argon	100		20-60		
(Continue	ous or special h	eating is not	required)	Trailing	N/A	N//	***************************************	N/A		
				Backing	Argon	100	%]	Oct-60		
8	L CHARACTE									
Current AC			C	Polarity			nt (GTAW)	ā		
Amps (Rang	ge)	500	Table	Volts (Rang	(e)	See Ta	able			
	lectrode Size		***************************************		*******	Thoriated 0.062 ure Tugnsten, 2% T	A THE REAL PROPERTY AND ADDRESS OF THE PARTY A			
INCLU OF IN	iomi ildildidi	TOI GHIATT	**************************************	(Spray arc, short circuiting arc, etc.)						
Electrode V	Vire feed spee	d range	4-4			s something we wan	N/A			
TECHNIQUE						2200				
String or W						Either				
	as Cup Size					1/4" to 1/2				
initial and If	nterpass Clear	ning			wechan	ical only (joint s	nali be dry pr	ior to welding)		
Method of h	ack gouging				Aechanical o	or Thermal /who	in required by	/ joint configuration)		
Oscillation	raok Boaging			*	noonanioen (N/A	John Coringulation,		
0	e to Work Dis	tence			N/A					
	Single Pass (p			Both						
	Single Electro			Single						
Travel Spee				See Table						
Peening				Not Allowed						
Other				N/A						
						DING TECHNIC	Name			
ļ		r	Passes may	₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽₽	CONTRACTOR OF THE PROPERTY OF THE PARTY OF T	ads or weave be	eads as requi	red.		
Current										
Weld	Electrode	Weld	Filler	Туре	AMP	Volts Range	Travel Speed	Other (e.g., Remarks, Comments)		
Process	FIGUR OGG.	Layer	Diameter	Polar.	Range	- Aire Valide	IPM/RPM	Ones fastis vestigate, continues)		
				i Vial.	Low - High		TO SHOW LATE OF			
GTAW			1/16"	1	50-130	10-18				
weld with	GTAW	Root/Fill	3/32"	Straight DC	50-175	12-20	As Required	No Comments		
Filler Metal			1/8"	(EN)	50-220	12-20				
						Company:		Petro Jotlustrial Solutions, LLC		
							1021	01		
Date:						By:	LACE !	july .		

		tro industrial So PO Box 263 Christiansted, V	103		Page 1 of 2
Al-	PROCEDURE	QUALIFICATIO	N RECORD	(PQR) PIS	L-GTAW-SS-PQR
		IX, ASME Boiler & I			
Company Name: Petro Indus Procedure Qualification Re WPS No. Welding Process (es) Types (Manual, Automatic,	strial Solutions, LLC cord No. PISL-GTAV PISL-GTAV GTAW	N-SS	d to Weld Test Date	Coupon Date of coupon for	or PQR
JOINTS		· · · · · · · · · · · · · · · · · · ·			
Joint Design Backing (Yee) (NO) Backing Material (Type) Metal Nonmetallic	N/A (Refer to backing & retainers.) (Refer to backing & retainers) Nonfusing M Other	letal	f # 1/16" r≊ 1/8" a≊ 30*		
BASE METALS	Market 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1	POSTWELD	HEAT TREA	TMENT	
Material Spec.	SA-312	Temperaratu			N/A
Type or Grade	Gr. B	Time			N/A
P-No. 8	to P-No. 8	Other		THE RESERVE THE PROPERTY OF THE PERSON NAMED IN COLUMN TWO IS NOT THE PERSON NAMED IN COLUMN TO	N/A
Thickness of Test Coupon	0.109"				
Diameter of Test Coupon	2				
Other	N/A				
<u> </u>		GAS		Per	cent Composition
	A-101-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-		Gas (es)	(Mixture)	Flow Rate
	<u></u>	Shielding	Argon	100%	20 - 60 CFH
FILLER METALS	1	Trailing	None	N/A	N/A
SFA Specification	5.9	Backing	Argon	100%	10 - 60 CFH
AWS Classification	ER316L		naracteristic		1 10-00 0111
Filler Metal Analysis A-No.	8	Current	idi dotorio iouo		Current (DC)
Size of Filler Metal	1/8"	Polarity			ight (EN)
Other	N/A	Amps.	***************************************	63 Volts	
	T	Tungsten Ele			62" 2% Thoriated
Deposited Weld Metal	0.109"	Other			N/A
POSITION		TECHNIQUE			
Position of Groove	6G	Travel Speed			3 IPM
Weld Progression (Uphill,Downhill)	Uphill	String or Wes			String
Other	N/A	Oscillation		***************************************	No
		Multipass or	Single Pass (per side)	Multipass
PREHEAT		Single or Mul			Single
Preheat Temp.	Amblent (>50°F)	Other		ALGORITA	N/A
Interpass Temp.	N/A			#L-W-	
Other	N/A				
			MINI - 1800 - 400	***************************************	***************************************

				,	dustrial So O Box 263	03	LC	Page 2 of 2
				Onns	tiansted, Vi	UUGZa		
			The second second second second	And in case of the last of the	JALIFICATI	THE RESERVE OF THE PARTY OF THE	the same of the sa) PISL-GTAW-SS-PQR
					ME Boiler & P nditions Used			
		7.44	record		ENSILE TE		est Coupon	
	1 11		- 1111	r			imate	
Specimen No.	Width (In)	Thickness (in)	Area (in²)		mate .oad (lb)		Strenght	Type of Failure & Location
T-01	0.77	0.112	0.086	7.0	080		psi) 2,100	Base Metal
	1	0.112	0.000		000	- OR	1,00	DOSC MICKET
T-02	0.78	0.111	0.087	7,	130	82	2,350	Base Metal
1000								es unitarii.
				GUID	ED - BEND	TESTS		
		and Figure Not Bend QW 46					Res ACCEF	
		it Bend QW 46 it Bend QW 46					ACCEF	
		e Bend QW 46					ACCEF	
		Bend QW 46					ACCEF	
				TOU	GHNESS T	ESTS		
Specimen	Notch	Matab T	Test	Impact	Latera	- William -		Drop Weight
No.	Location	Notch Type	Temp.	Values	% Shear	Mils	Break	No Break
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A N/A	N/A N/A	N/A N/A	N/A N/A	N/A N/A	N/A N/A	N/A N/A	N/A N/A	N/A N/A
11/71	NIA	IVA	NUA	IVA	13//	INA	I INA	IN/A
				FILLL	ET-WELDS	TEST		
Result-Satisfo	actory: Yes	N/A	No	N/A	Penetration in	to Parent Me	ital: Yes/No	N/A
MacroRres	n alt					N/A		
vidulo-ities	unt	-				IWA		
				0	THER TEST	rs		
Type of Test	ì					N/A		
Deposited A						N/A		
Other						N/A		
			***************	***************************************				
Velder's Na	me:	Dar	iel Martine	Z	Clock No.	6941	_Stamp No	6941
Tests condu	cted by:			INI Co	orp.			
Mechanical 1	Test Condu	cted by:		Gilberto	Martinez		Test No.	PISL-052918-01
			rd are correc	The same of the same		vere prepai		ested in accordance with the
		of the ASME C				- Frakw		
						Company	: Petro	Industrian Solutions, LLC
Date:		29-May-2018				Ву:	M	IlV

		Petro Industrial S PO Box 28 Christiansted,	303
		ING PROCEDURE SP Clion IX, ASME Boller & P	
Company Name: Petro Indus Welding Procedure No.	PISL-SMAW-P1	By:	Supporting PQR No. PISL-SMAW-P1-PQR
Rev. No. 0 Welding Process (es) SN	Date IAW	Type (s)	Manual (Automatic, Manual, Machine, or Semi-Auto)
Metal Nonmetallic Joint Design Backing (Yes) (NO) Backing Material (Type)	N/A Fer to backing & relainers) Nonfusing & Other U - Groove X	Metal	DETALS A H M A H
Joint Design <u>Branct</u> Backing (Yes) (NO) Backing Material (Type)	er to backing & retainers.) Connection X		THE PART OF THE PA
Backing (Yes)(NO) Backing Material (Type) (Ref	E Connection X N/A er to backing & retainers.) er to backing & retainers.)		# 10 - 6 0 - 50 - 50 - 5
Backing (Yes) (NO) Backing Material (Type) (Ref	N/A r to backing & retainers.) er to backing & retainers.)		ALL JOINTS

10/50/2014/51/5		Putro Industrial Sol PO Box 783	33	Page 2 of 3
ENTRE INSTRUMENT		Christiansted, VI		THE PROPERTY OF THE PARTY OF TH
	44	ELDING PROCEDURE SPEC (Section IX, ASME Boiler & Pre		(WPS) PISL-SMAW-P1
JOINTS (CONT'D) Joint Design	Contrat Model	DETAILS		
Backing (Yes)(N	O) X	(see below)	
Backing Material (Type) _	N/A	•		
Metal	(Refer to backing & retainers			
Nonesete	Nonfusin Other	A water		
	Th. (4)	was the are thanese		
	CATA			
	* 1	 100 To OP Prof. THECASESS OF THE STORY OF THE SERVED AS COLUMN DISCUSSION OF THE PRESENCE AS COLUMN DESCRIPTION OF THE PRESENCE AS CO	OPHERWISE.	
		THE COUNTY OF THE PARKED ACK, EC.	(X)08/3/5/5	
	7	APPROPRIATE Y CIEX- BECOME YKS	046	
	\			
	L-V-1			
8600/29	REPOSSE VIEW DAVE OF MUNICIPAL BROOMS I	TR SOCKET WOLDING COMPONENTS	Olmer than Flanges	
			·····	
FROM MORE	504 5450 Fact 640	Brych (METO) - ROCK La	assimple of surox	
			- VEV	
		****	EARLS I	
1 5 Tr	ai (3 2 3	
80 100 1	po 40 /	(A) 40 (A)	PPROPAGELY	
		4	IN A BEFORE WELDING	
A MAN A TATHOR	THE THICKNESS OF THE HUS WI	HEREVER'S SMALLER ONLESS OF	VERN SERSOURED BY	
Y 235 A TO DE 134		S C D-EPVASE PECAMPED BY THE FAR		
in * NOMENALE	PARTHALL PRODUCESS			
	RECOMPENDED WELD	NG DAVENSIONS FOR FLANCIES		
Base Metals			- L	
P-No 1 OR	Group No. 1	to P-No 1	Group No.	2
	on Type and grade	Spec SA 53/105/108/13	1/135/178/179/181/192/2	10/211/234/266/533/334/350/372
to specification type		Spec SA 53/105/106/134	1/135/178/179/181/192/2	10/211/234/288/333/334/350/372
OR	*****			
Chem. Analysis and to Chem. Analysis and			N/A N/A	
Thickness Range:	d telecon: 7 top	***************************************	NA	
Base Metal:			0.0625" to 0.436"	Luia - a con
Pipe Dia. Range:	**************************************		1" OD to Unlimite	ed
Filler Metals			Pool 8 Edi	
Spec. No. (SFA)		Root & Fill A5.1	
AWS No. (CL/			E6010 / E-7018	
F-No:		3	(E-6010) / 4 (E-7018)	
A-No. Size of Filler Metal	ACCORDING TO A CARLON CONTRACTOR		3/32", 1/8"	
Filler Metal Form	******	E	lectrode (Core Wire)	
Deposited Weld Metal	THE PARTY OF THE P	**************************************	25" max / (E-7018) 0.436	i" max
Thickness Range (Groov			0.0625" to 0.436"	
Thickness Range (File Electrode-Flux (class)			All N/A	7711
Flux Trade Name			N/A	
Consumable Insert			N/A	
Other		Maxir	num Miselignment≂ 3/32	

				Petro	Industrial PO Box	Page 3 of 3				
				Ch		VI 00824				
1 547					17- 16-3					
				***********************************	WAAAAAA AAAAA	CIFICATIONS	CONTRACTOR SECTION AND ADDRESS OF THE PARTY	(WPS) PISL-SMAW-P1		
SOCITIONS			(See			& Pressure Ves	ssel Code)	WHIRE AND A		
POSITIONS Position (s)	Programme and the second of th	- A	LL	DANCOMORPHAN AND ALINOWSPRING	D HEAT TRE	AIMENT		AMA		
	ogression: Up	/ Down	l Up	Temperatu Time Rang				N/A N/A		
Position (s)		22 9 00000000000000000000000000000000000	I/A	Time Kang	9		www.interference.	N/A		
				IGAS	I Pe	rcent Composi	tion			
PREHEAT					Gas (s)	(Mict)		Flow Rate		
Preheat Ten	np.	50°	F Min	1						
nterpass To	emp.	50"F Min /	500°F Max	Standing	N/A	N/A	4	N/A		
(Continuo	us or special h	estina is na	t required)	Trailing	N/A	N/A	١	N/A		
Commo	da or apecial fi	odding is no	t required/	Backing	N/A	N/A	\	N/A		
					many of the part			TE TO THE TOTAL TO		
	L CHARACTE			_						
Current AC			DC	Polarity		EP (Reverse)	2			
Imps (Range) See Table		Volta (Ran	ge)	See Table	and the same of th					
Tungsten F	lectrode Size	and Type					N/A			
Millianou E		enn ilha	******	······	{P	ure Tugnsten, 2% T		ed, etc.)		
Mode of M	etal Transfer	for GMAW					N/A			
			http://www.		(Spray arc, short circuiting arc, etc.)					
Electrode W	Vire feed spee	d range					N/A			

	E				······································			-		
LECHNIQUE										
String or W	eave Bead					Either				
String or Wi Orifice or G	eave Bead as Cup Size		,	W-11/	N/A		4			
String or Wi Orifice or G	eave Bead				A CONTRACTOR AND A STREET OF THE PARTY OF TH	Either	hall be dry prio	r to welding)		
	eave Bead as Cup Size		***************************************	······································	A CONTRACTOR AND A STREET OF THE PARTY OF TH		hall be dry prio	r to welding)		
String or Wo Orifice or G Initial and Ir	eave Bead as Cup Size nterpass Clea		***************************************		Mechan	ical only (joint s	***************************************			
String or Wo Driffice or G nitial and in Method of b	eave Bead as Cup Size		17		Mechan	ical only (joint s	on required by jo	r to welding)		
String or Wo Drifice or G nitial and in Method of b Decillation	eave Bead as Cup Size nterpass Clea ack gouging	ning			Mechan	ical only (joint s	on required by jo			
String or Wi Orifice or G nitial and Ir Method of b Decillation Contact Tub	eave Bead as Cup Size nterpass Clea ack gouging be to Work Di	ning otance	11 11 11 11 11 11 11 11 11 11 11 11 11	N.	Mechan	nical only (joint s	on required by jo N/A N/A			
String or Wi Drifice or G nitial and in Method of b Decillation Contact Tub Multiple or S	eave Bead as Cup Size nterpass Clea cack gouging be to Work Di Single Pass ()	ning stance per side)	12 12 12 12 12 12 12 12 12 12 12 12 12 1		Mechan	nical only (joint s	on required by jo N/A N/A Both			
String or Wi Orifice or G initial and Ir Method of b Oscillation Contact Tub Multiple or S Multiple or S	eave Bead as Cup Size nterpass Clea cack gouging be to Work Di Single Pass () Single Electro	ning stance per side)	***************************************	···	Mechan	or Thermal (whe	on required by jo N/A N/A Both Single			
String or Wi Driftce or G nitial and in Method of b Deciliation Contact Tut Multiple or S Multiple or S Fravel Spee	eave Bead as Cup Size nterpass Clea cack gouging be to Work Di Single Pass ()	ning stance per side)	**************************************		Mechan	or Thermal (whe	on required by jo N/A N/A Both Single e Table			
String or W. Drifice or G nitial and in Wethod of b Dacillation Contact Tut Multiple or S Travel Spee	eave Bead as Cup Size nterpass Clea cack gouging be to Work Di Single Pass () Single Electro	ning stance per side)	**************************************		Mechan	or Thermal (whe	on required by jo N/A N/A Both Single			
String or W. Drifice or G nitial and in Wethod of b Dacillation Contact Tut Multiple or S Travel Spee	eave Bead as Cup Size nterpass Clea cack gouging be to Work Di Single Pass () Single Electro	ning stance per side)			Mechan	or Thermal (whe	on required by jo N/A N/A Both Single e Table Allowed			
String or W. Drifice or G Initial and in Method of b Dacillation Contact Tul Multiple or S Multiple or S Travel Spee	eave Bead as Cup Size nterpass Clea cack gouging be to Work Di Single Pass () Single Electro	ning stance per side)	12 24 24 24 24 24 24 24 24 24 24 24 24 24	SMAW GE	Mechanical of	or Thermal (when see Not	on required by jo N/A N/A Both Single e Table Allowed N/A	oint configuration)		
String or W. Drifice or G nitial and in Wethod of b Dacillation Contact Tut Multiple or S Travel Spee	eave Bead as Cup Size nterpass Clea cack gouging be to Work Di Single Pass () Single Electro	ning stance per side)	Passes may	SMAW GE	Mechanical of	or Thermal (whe	on required by jo N/A N/A Both Single e Table Allowed N/A	oint configuration)		
String or W. Drifice or G Initial and in Method of b Dacillation Contact Tul Multiple or S Multiple or S Travel Spee	eave Bead as Cup Size nterpass Clea cack gouging be to Work Di Single Pass () Single Electro	ning stance per side)	Passes may	SMAW GE	Mechanical of Me	or Thermal (when see Not	on required by jo N/A N/A Both Single e Table Allowed N/A	oint configuration)		
String or W. Drifice or G nitial and in Hethod of b Decillation Contact Tul Hultiple or S Travel Spee	eave Bead as Cup Size interpass Clea pack gouging be to Work Di Single Pass (I Single Electro dd (RANGE)	ning stance per side)	Passes may	SMAW GE be made with Cur	Mechanical of Me	or Thermal (when see Not DING TECHNIC	on required by jo N/A N/A Both Single e Table Allowed N/A	oint configuration)		
String or Wi Drifice or G Initial and in Method of b Decillation Contact Tul Multiple or S Multiple or S Travel Spee Psening Other	eave Bead as Cup Size nterpass Clea cack gouging be to Work Di Single Pass () Single Electro	ning stance per side) pdes		SMAW GE be made with Cur	Mechanical of Me	or Thermal (when see Not	on required by jo N/A N/A Both Single e Table Allowed N/A QUE beads as require Travel Speed	oint configuration)		
String or Wi Drifice or G nitial and in flethod of b Decillation Contact Tul fluitiple or S fravel Spee Peening Other	eave Bead as Cup Size interpass Clea pack gouging be to Work Di Single Pass (I Single Electro dd (RANGE)	etance per side) ides	Filler	SMAW GE be made with Cur	Mechanical of Me	or Thermal (when see Not DING TECHNIC	on required by jo N/A N/A Both Single e Table Allowed N/A	oint configuration)		
String or Wi Driftce or G Driftce or G Method of b Decillation Contact Tul Multiple or S Multiple or S Travel Spee Peening Other	eave Bead as Cup Size nterpass Clea clean	etance per side) ides Weld Layer	Filler Diameter	SMAW GEI be made wil Cui Type Polar.	Mechanical of Me	or Thermal (when the second of	on required by journal N/A N/A Both Single a Table Allowed N/A DUE peads as require Travel Speed IPM/RPM	oint configuration) ed. Other (e.g., Remarks, Comments		
String or Wi Orifice or G initial and in Method of b Oscillation Contact Tub Multiple or S Fravel Spee Peening Other	eave Bead as Cup Size interpass Clea pack gouging be to Work Di Single Pass (I Single Electro dd (RANGE)	etance per side) ides	Filler	SMAW GE be made with Cur	Mechanical of Me	or Thermal (when see Not DING TECHNIC	on required by jo N/A N/A Both Single e Table Allowed N/A QUE beads as require Travel Speed	oint configuration)		
String or Wi Orifice or G initial and in Method of b Decillation Contact Tub Multiple or S Multiple or S Fravel Spee Peening Other Weld Process	eave Bead as Cup Size nterpass Clea clean	etance per side) ides Weld Layer	Filler Diameter	SMAW GEI be made wil Cui Type Polar.	Mechanical of Me	or Thermal (when the second of	on required by journal N/A N/A Both Single a Table Allowed N/A DUE peads as require Travel Speed IPM/RPM	oint configuration) ed. Other (e.g., Remarks, Comments		

CONFIDENTIAL VITOL-011985

Exhibit I

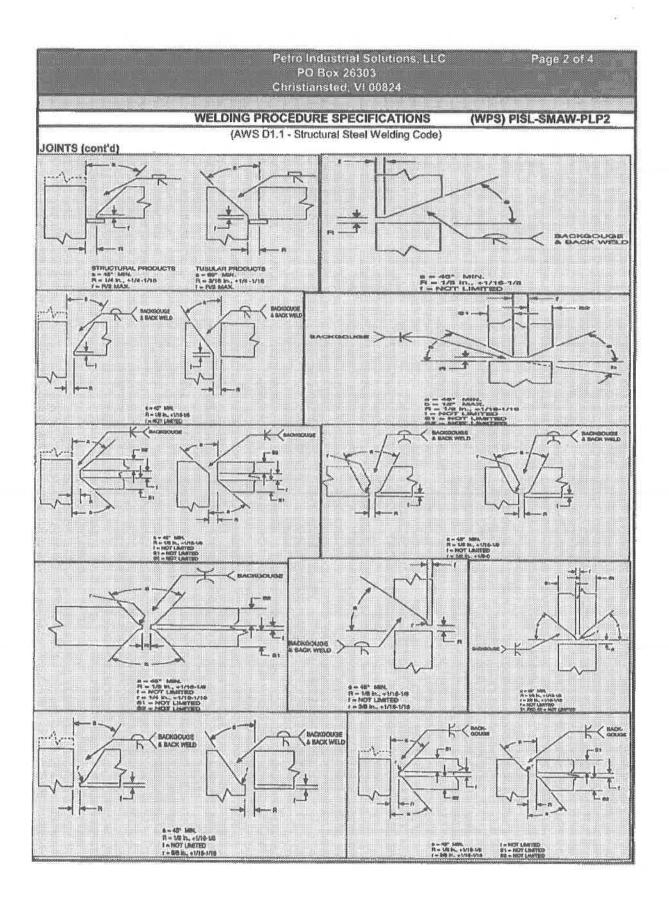
	Petr	o industrial So	lutions, LLC		Page 1 of 2	
	t			100 April 100 Ap		
		T TEMPER				
	WHAT IS NOT THE OWNER, OF THE OWNER, WHEN PARTY OF THE OWNER, WHEN PART	WERE DATE OF THE PARTY OF THE P	AND RESIDENCE OF THE PROPERTY		MAW-P1-POR	
F				Coupon		
and Ma						
ora no.			Date	30-May-2018		
			INIO (ONANA)			
Semi-Auto)			ING (SNAVV))		
willi-Adw)	INCHORE THE	CLDING				

Single \	/ - Groove					
X				3,6	EACT I	
N/A			f = 1/16"	7		
(Refer to backing &	retainers.)		r= 1/8"	Y-111-11-11-11-11-11-11-11-11-11-11-11-1		
(Refer to backing &	retainers.)		a= 35°		\	
	Nonfusing Me	tal		(C.2)		
	Other				-1/	
		POSTWELD	HEAT TREA	TMENT	The state of the s	
		Temperaratur	e		N/A	
	r. B	Time			N/A	
to P-No.	1	Other			N/A	
,					- Auto-	

N/A		The second second				
		GAS	2.00		nt Composition	
***************************************					Flow Rate	
				The second secon	N/A	
the same of the sa	THE RESERVE AND ADDRESS OF THE PARTY OF THE			CONTRACTOR OF THE PROPERTY OF	N/A	
Additional and the second second second second					N/A	
CONTROL OF THE PARTY OF THE PAR	The second secon		aracteristics			
Andrew Commission Comm	and the second s				· · · · · · · · · · · · · · · · · · ·	
The second secon	The same of the sa				www	
			otrada Cina	90-115 Volts	21-25	
14/7	14/2		ctrode Size		N/A	
0.125"	0.175"	Other	anni de la companya d	N/A	\	
		TECHNIQUE				
6	SG .				3 IPM	
	_ f_ 15#	String or Wes		to a substantial and a substan	String	
Uj	DUIT			54444444444		
	I/A	Oscillation				
		Oscillation Multipass or 9		er side)	No	
		Oscillation	Single Pass (p		No Multipass	
N		Oscillation Multipass or S	Single Pass (p		No Multipass Single	
Ambien	VA	Oscillation Multipass or S Single or Multi	Single Pass (p		No Multipass	
	Single \ X N/A (Refer to backing & Refer to backing	PROCEDURE (See Section IX Record of Actue Petro Industrice Petro Industric	PROCEDURE QUALIFICATION (See Section IX, ASME Boiler & F Record of Actual Conditions Used Petro Industrial Solution, LLC ord No. PISL-SMAW-P1-PQR PISL-SMAW-P1 SHIELD METAL ARC WELD MANUAL WELDING Single V - Groove X N/A (Refer to backing & retainers.) Nonfusing Metal Other SA-106 Gr. B To P-No. 1 0.300" 3" N/A GAS Shielding Trailing Backing E-6010 E-7018 Electrical Ch 1 1 Current 1/8" 1/8" Polarity N/A N/A N/A N/A N/A N/A N/A Tungsten Electrical Cher 1/8" 1/8" Polarity N/A N/A N/A Tungsten Electrical Cher 0.125" 0.175" TECHNIQUE Travel Speed	PO Box 26303 Christianstori, VI 90824 PROCEDURE QUALIFICATION RECORD (See Section IX, ASME Boiler & Pressure Vesse Record of Actual Conditions Used to Weld Tests Petro Industrial Solution, LLC Ford No. PISL-SMAW-P1-PQR Date PISL-SMAW-P1 SHIELD METAL ARC WELDING (SMAW) MANUAL WELDING Single V - Groove X	PROCEDURE QUALIFICATION RECORD (See Section IX, ASME Boiler & Pressure Vessel Code) Record of Actual Conditions Used to Weld Test Coupon Petro Industrial Solution, LLC PISL-SMAW-P1-PQR Date 30-May-2018 PISL-SMAW-P1 SHIELD METAL ARC WELDING (SMAW) MANUAL WELDING Single V - Groove X N/A (Refer to backing & retainers.) (Refer to P-No. 1 0.300" 3" N/A GAS Gas (es) (Mixture) Shielding N/A N/A F=010 E-7018 Electrical Characteristics 1 1 1 Current 1/8" N/A	

				F	dustrial Sol 20 Box 2630 transted, VI	73	LC	Page 1 of 2
ه کنیدا		indense ji b			JALIFICATIO		RD (PQR	PISL-SMAW-P1-PQR
			(See Sec	tion IX, ASN	ME Boiler & Pi	ressure Ve	Married Company of the Party of	AND THE PROPERTY OF THE PARTY O
			Record o		nditions Used		est Coupon	7775147754
				T	ENSILE TES			
Specimen No.	Width (in)	Thickness (in)	Area (in²)		nate oad (lb)	Ultimate Tensile Strenght (psl)		Type of Failure & Location
T-01	0.750	0.300	0.225	14,557		64	,700	Ductile/Base Metal
T-02	0.751	0.302	0.228	14,	765	65	,100	Ductile/Base Metal
				GUIDI	ED - BEND 1	TESTS		
		e and Figure N					Resi	
	R-1 Root Bend QW 462.3 (a) R-2 Root Bend QW 462.3 (a)						ACCEP	
R-2 Root Bend QW 462.3 (a) F-1 Face Bend QW 462.3 (a)							ACCEP	
F-2 Face Bend QW 462.3 (a)							ACCEP ACCEP	
	1"-4 F'0U	Delia WYY 40	, E. U (a)			11.5 5 (11	ACCEP	TEO
				CHICAGO III	GHNESS TE	5-40		III
Specimen	Notch	Notch Type	Test	Impact	Lateral		1	Drop Weight
No.	Location		Temp.	Values	% Shear	Mils	Break	No Break
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A N/A	N/A N/A	N/A N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A N/A	N/A N/A	N/A N/A	N/A N/A	N/A N/A	N/A N/A
ResultSatisf	cactory: Yes	_N/A	No	1	ET-WELDS		tal: Yes/No	N/A
	eralt					NI/A		
MacroRres	oun	_				N/A		
MacroRres	suit			0	THER TEST			
				0	THER TES1	rs		
Type of Tes	t			0	THER TEST			
MacroRres Type of Tes Deposited A Other	t		14.	0	THER TEST	rs N/A	2)141	1022 121111111
Type of Tes Deposited A	t		***************************************	0	THER TEST	N/A N/A		
Type of Tes Deposited A Other	t nalysis	Dan	iel Marlinez			N/A N/A N/A	Stamp No	6941
Type of Tes Deposited A Other Welder's Na	t inalysis ime:	Dan	iel Marlinez		Clock No.	N/A N/A N/A	_Stamp No	6941
Type of Tes Deposited A Other Welder's Na Tests condu	t inalysis ime:	10.51	iel Martinez	INI Co	Clock No.	N/A N/A N/A	_Stamp No	
Type of Tes Deposited A Other Welder's Na Tests condu Mechanical We Certify th	t nalysis me: cted by: Test Conductat the statement	cted by:	rd are correct	INI Co	Clock No orp. Martinez e test welds w	N/A N/A N/A 6941	Te t No.	PISL-053018-01 ested in accordance with the
Type of Tes Deposited A Other Welder's Na Tests condu Mechanical We Certify th	t inalysis ime: icted by: Test Condui at the statement of Section IX	cted by: ents in this recoi	rd are correct	INI Co	Clock No orp. Martinez e test welds w	N/A N/A N/A 6941	Te t No.	PISL-053018-01 asted in accordance with the Industrial Solutions, LLC

	Petro Industrial S PO Box 26 Christiansted	303	Page 1 of 4
	G PROCEDURE SPE WS D1.1 - Structural Str	CONTRACTOR OF THE PARTY OF THE	PS) PISL-SMAW-PLP2
Company Name: Petro Industrial Solutions, LLC Welding Procedure No. PISL-SMAW-PLP2 Rev. No. 0 Date Welding Process (es) SMAW	By: Date Type (s)	Supporting PQR No. Manual (Automatic, Manual, Machine, or \$	
JOINTS (Joints permitted in the latest edition of Joint Design Fillet Weld Backing (Yes) (NO) X Backing Material (Type) N/A	of AWS D1.1 are also p	ernitted)	ALL JOINTS
Backing Material (when required): Carbon Steel P-1/G	Group 1, 2 or 3		
STRUCTURAL PRODUCTS TUBULAR PRODUCTS = 45° MIN. R = 1/4 III. R = 376 III. +1/4-1/16 R = 376 III. +1/4-1/16		ETRUCTURAL PRODUCTS = -89° MIN. B - 1/4 In. +1/4 - 1/18 = 8/2 MAX.	TUBLIAN PRODUCTS A SO MINI B - 2016 In, -11/4-1/16 1 - 772 MAX
BACK W BACK W	Ougle a read	F = 100 Ma F = 100 Ma F = 100 Ma	BACKGOUGE & BACK WELD &
a AND to = 60° hibt. R = 10 in, etitle-tus 1 in NOT LIMITED Si = NOT LIMITED Si = NOT LIMITED		STRUCTURAL PRODUCTS 8 = 45° MIN. R = 1/4 In., +1/4-1/16 1 = R/2 MAX.	TUBULAR PRODUCTS a = 60° MIN. A = 3/18 in., +1/4 -1/18 L = R/2 MAX.



	WEI	DING PE	OCEDURE SP	ECIPICA	TIONS	WPS) PISL-SHAW-PLP2		
CONTRACTOR DESCRIPTION OF THE PARTY OF THE P		AND ADDRESS OF THE OWNER, OF	1.1 - Structural	CONTRACTOR OF THE PERSON NAMED IN	THE RESIDENCE OF THE PERSON NAMED OF THE PERSO	er a) Fiot anow-Ftrz		
Base Metals	**************************************	*****************				//////////////////////////////////////		
P-No. 1	Group No	1	to P-No.	1	Group No.	2		
And the second s	ype and grade	A-38 A-	572 Gr.45/50/56/9	070: A-518	Gr.70. A-588. A-514 T-1	A-285 Gr.C. A-515 Gr.70, A-263 Gr.D		
to specification type and OR	d grade					A-285 Gr.C, A-515 Gr.70 A-283 Gr.D		
Chem. Analysis and Med	ch. Prop.				N/A			
to Chem. Analysis and Me		***		N/A				
Thickness Range:								
Base Metal;	****			· ·	0.125" to 1.500"			
Pipe Dia. Range:	1400	1" OD to Unlimited						
iller Metala	/*** -/**	*****		F	Root & Fill			
Spec. No. (SFA	A5.1							
AWS No. (CLASS		The state of the s	****************	E-70XX				
F-No.		4						
A-No.		1 200 400 2000						
Size of Filler Metal Filler Metal Form		3/32", 1/8", 5/32" Electrole (Core Wise)						
Deposited Weld Metal	······································	Electrode (Core Wire) 1.500° max, (stus reinforcement)						
Thickness Range (Groove)	***************************************	0.125" to 1.500"						
Thickness Range (Fillet)		0.125° mln.						
Electrode-Flux (class)		N/A						
Flux Trade Name		N/A						
Consumable Insert		N/A						
Other	Nonmetaliko or nonfusing metal reteiners are not permitted							

				Petro	industrial PO Box	Solutions, LI 26303	.c	Page 4 of 4	
				CI		J. VI 00824			
					10.30				
			WELDING	PROCED	URE SPEC	IFICATIONS		(WPS) PISL-SMAW-PLP2	
						Steel Welding C	Code)		
POSITIONS			LL	Commercial	D HEAT TR	EATMENT			
Position (s) of Groove Temperature						AV		N/A	
Welding Prog		-	l Up	Time Rang	 	·		N/A	
Position (s) o	T FILLET	1r	l/A		·				
				GAS	The same of the sa	rcent Compos	~~~~~~~		
PREHEAT Preheat Temp			- A4:	ļ	Gas (s)	(Mixt	ure)	Flow Rate	
Interpass Ten			F Min 500°F Max	Standing	T AI/A	T 50/		T	
interpass ren	np.	00 F WITT /	JUU F IVIAX	Trailing	N/A N/A	N/	· · · · · · · · · · · · · · · · · · ·	l NA	
(Continuous	or special i	heating is no	t required)	Backing	N/A	l N/	***********	N/A N/A	
				Decking	LINO	1		I N/A	
ELECTRICAL	CHARACT	EDISTICS	***************************************						
Current AC or			C	Polarity	,	EP (Reverse)			
Amps (Range) See Table		Volts (Ran		See Table	•				
anpo (rango	'		1000	A Arto firmi	Re)	366 1 3016	•		
Tungsten Elec	ctrode Size	and Type					N/A		
					ξF	Pera Tugnsten, 2% T		rialed, etc.)	
Mode of Meta	al Transfer	for GMAW					N/A		
			***************************************		(Spray arc, short circulling arc, etc.)				
Electrode Wir	e feed spec	ad range	411440000000000000000000000000000000000	MILLE WAS COLORS			N/A		
TECHNIQUE					minorium management				
String or Wea						Either			
Orifice or Gas			***************************************		N/A				
nitial and Inte	rpass Clea	ıning			Mechar	nical only (joint s	hall be dry p	rior to welding)	
								TO THE THE TEXT OF	
Wethod of bac	ck gouging				Mechanical (or Thermal (whe		y joint configuration)	
Oscillation					N/A				
Contact Tube							N/A		
Multiple or Sir							Both		
Multiple or Sir	-	2088				-	Either		
Fravel Speed ((KANGE)						e Table		
eening Other							Allowed	. 4 8 4 9	
JU181						Maximum be	ad inicknes =	1/4"	
			Warrania and American	CMANY OC	UEDAL ME	DING TECHT	51 F		
			Paceae mare		***********************	DING TECHNIC		uirod	
·····			assos may	Environment in community teachfre	n sinnger be rent	eads or weave b	edus as requ	med.	
Wels		184-1 1	perm .	- Our	AMP		Travel		
Weld E	Electrode	Weld	Filler	Туре	Range	Volts Range	Speed	Other (e.g., Remarks, Comments)	
Process		Layer	Diameter	Polar.			IPM/RPM	,	
					Low - High				
		As	3/32"		70-110	18-23			
SMAW	E-7018	Required	1/8"	Reverse	90-150	21-24	As Required	Holding Oven (50°F to 250°F)	
			5/32"	<u> </u>	120-190	24-26			
						Company:		Petro Industrial Solutions, LLC	
Date:						D	la	Ost IV	
vale.						Ву:	1/0	THE CONTRACTOR OF THE CONTRACT	

		tro Industrial Sol PO Box 263 Christiansted, VI	13		Page 1 of 2		
		Cimsumsted, V	00524				
		QUALIFICATION			MAW-PLP2-PQR		
Company Name: Procedure Qualification Reco WPS No. Welding Process (es) Types (Manual, Automatic, S	Record of Actu Petro Indus ord No. PISL-SMAN PISL-SMAN SHIELD MI	ETAL ARC WELD	to Weld Test Co C Date 2				
OINTS	**-						
Joint Design : <u>Single V-Grooy</u> Backing Material (Typa): <u>A-3</u>							
ASE METALS	1100	POSTWELD	HEAT TREATI	AENT			
Material Spec.	A-36	Temperaratur	е	7.00	N/A		
Type or Grade	N/A	Time	Time N/A				
P-No. 1	to P-No. 1	Other N/A			N/A		
Thickness of Test Coupon	1.000"						
Diameter of Test Coupon	N/A			30.4.0	·		
Other	N/A		w 1860 1860 1860 18		- 100 - 100		
		GAS			ent Composition		
		Chi-ldi-	Gas (es)	(Mixture) N/A	Flow Rate N/A		
FILLER METALS	1	Shielding	N/A	N/A	N/A		
FILLER METALS SFA Specification	5,1	Trailing Backing	N/A	N/A	N/A N/A		
WS Classification	E-7018	Electrical Ch	THE RESERVE THE PARTY OF THE PA	14/74	1 140		
Filler Metal Analysis A-No.	1	Current		Direct Current (DC			
Size of Filler Metal	1/8"	Polarity		Reverse (EP)			
Other	N/A	Amps.		90-125 Volts	22		
		Tungsten Ele	ctrode Size		N/A		
Deposited Weld Metal	1.000*	Other		N	/A		
POSITION		TECHNIQUE					
Position of Groove	3G	Travel Speed			4 IPM		
Veld Progression (Uphili,Downhill)	Uphill	String or Wea	ve Bead		String		
Other	N/A	Oscillation			No		
			Single Pass (per		Multipass		
PREHEAT			ipass Electrode	98	Single		
Preheat Temp.	Ambient (>50°F)	Other			N/A		
Interpass Temp.	500°F max N/A						

	West of			1	dustrial Sc 20 Box 26: tiansted, V	03	re	Page 2 of 2
		///			ALIFICATIO			OR) PISL-SMAW-PLP2-PQR
					tructural Ste			
		WWW.W-11.01	Record		nditions Use ENSILE TE		est Coupon	
ter tirte/	T The North Control	T	OUT THE STATE OF T	r		Interest and the second	mate	T
Specimen No.	Width (in)	Thickness (in)	Area (in²)		Ultimate Total Load (lb)		Strenght osi)	Type of Failure & Location
T-01	0.751	1.001	0.752	44,	,616 59,350			Ductile/Base Metal
T-02	0.752	1.003	0.754	45	218	59	,950	Ductile/Base Metal
		L-114		CHID	ED - BEND	TESTS		
		уре (Fig. 4.6)		GUID	ED - BEND	16919		
		S-1 Side Bend						Result CEPTED
		3-1 Side Bend 3-2 Side Bend						CEPTED
		S-3 Side Bend						CEPTED
S-4 Side Bend					- Hillion - nove - S			CEPTED
				TOU	GHNESS 1	ESTS		
Specimen	Notch	Notch Type	Test	Impact	Latera	al Exp.	1	Drop Weight
No.	Location		Temp.	Values	% Shear	Mils	Break	No Break
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A N/A	N/A N/A	N/A N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	I N/A J	IN/A	N/A	N/A	N/A	N/A	N/A	l N/A
ResultSatisfo	actory: Yes	_N/A	No		ET-WELDS		al: Yes/No	N/A
MacroRres	ult	9				N/A		
				o	THER TES	TS		
Type of Test						N/A		
Deposited A			***************************************	***************************************		N/A	***************************************	
Other	7					N/A		
Welder's Nar	ne:	Dar	iel Martinez	······································			Stamp No.	6941
ests conduc	cted by:			INI Co	np.			
/lechanical 1	est Conduc	ted by:			Martinez		Test No.	PISL-052418-01
We Certify tha	t the stateme		d are correcting Code.			vere prepare	ed, welded, a	nd tested in accordance with the
						Company:		etro Industrial Solutions, LLC
Date:		24-May-2018				Ву:	Į,	in (I)
							7	<i>V</i>

Welder's Name	Edgardo Batista		ID. #	9325	Stamp #	EB (74)
WPS No.		PISL-GTAW-S	SS			
Welding Process(es)	Gas Tungst	en Arc Welding (G	TAW)		Type Man	ual
Base Material(s)	A-106 Gr. B	То	SA-106 Gr. B		Thickness _	0.147"
Manual or Semi-Automatic V	ariables for Each F	Process	Actual Val	ues	Range Qu	alified
Backing		WILL TO THE STATE OF THE STATE	F6- Without		F6-With/Wit	hout
			P1 to P1		P1 to P15	E
Plate X Pipe (enter diar	meter, if pipe)		1/2"		1/2" NPS Min	imum
		Root/Fill	5.18		5.18	
Filler Metal Specification (SFA) Classification ——		-		+	
		Root/Fill	6		6	
Filler Metal Group No.		_	×000000000000000000000000000000000000			
Filler Metal Product Form ——			Solid Rod		Solid Ro	d
Consumable Insert for GTAW		-	None		None	
		F 6	0.147"		0.294" Maxi	mum
Weld Deposit Thickness ——			-	***************************************	-	
Welding Position		-	6G (Three Coup	oon)*	All	- III 16W-00
Maximum Deposition Rate		<u></u>	N/A			MINISTER - 11111102
Welding Progression (Uphill/ I	Downhill)		Uphill		- Uphill	
Backing Gas for GTAW, PAW,			None	None With/ Without		Argon
GMAW Transfer Mode ———			N/A	N/A N/A		
FCAW/ GTAW Welding Curren		1800	DC/ EN	DC/ EN DC/		
*Remarks: * Total weld length:						
Guide Bend Test Results						
- Side	X Trans. Root (R)	& Face (F)	Long. Root	& Face	Res	sults
*	T-011419-74-R1-Fig	gure QW-462.3 (a)			Acce	ptable
	T-011419-74-R2-Fig	gure QW-462.3 (a)			Acce	ptable
-	T-011419-74-F1-Fig	gure QW-462.3 (a)			Acce	ptable
	T-011419-74-F2-Fig	gure QW-462.3 (a)			Acce	ptable
Radiographic Test Results:		Vone				
Visual Examination Results:	Face: Acceptable	Root: Accep	otable			
Welding Test Conducted By:	Guil	lermo Castro, LIII				
Mechanical Tests Conducted	By: Acure	en Inspection Servi	ces Lat	oratory	Test No. PAUT02	1621-EB
We certify that the statement accordance with the requirem	ents of ASME Section	n IX/2013	the test coupons	were pr	repared, welded,	tested in
Organization:	Petro Industrial Sol	allons, LLC				
Ву:	Much		Date:	02/19/2	2021	
	Adrian Melendez Jr.	, PM				

Welder's Name	Bernardo Cruz		ID. #	9788	Stamp # BC	
INITIO NA	TO HE	PISL-GTAW-S	3			
Welding Process(es)		sten Arc Welding (GT	AVV)	Тура	Manual	
Base Material(s)		То		SA-106 Gr. B Th		
Manual or Semi-Automa	***************************************	Process	Actual Value	108	Range Qualified	
Backing			F6- Without		F6-With/Without	
ASME P-No. To P- No),		P1 to P1		P1 to P15E	
	r diameter, if pipe)	Root/Fill	1/2"	1	/2" NPS Minimum	
	ineas of the street	Keovriii —	5.18		5.18	
Filler Metal Specification	(SFA) Glassification —		-		-	
		RoovFill	6		6	
Filler Metal Group No					-	
Filler Metal Product Forn		I	Solid Rod		Solid Rod	
			None		None	
Consumable Insert for G	TAW OF PAVI	F 6	0.147"		0.294" Maximum	
Weld Deposit Thickness	- minor			11111		
Welding Position			6G (Three Cou	All		
Maximum Deposition Ra			N/A			
Welding Progression (Up			Uphill	Uphill		
Backing Gas for GTAW.			None	,	Nith/ Without Argo	
GMAW Transfer Mode —	and the second s		N/A		N/A	
FCAW/ GTAW Welding			DC/ EN	DC/ EN		
*Remarks: * Total weld le				- 100 market		
- militim						
Guide Bend Test Re						
- Side	X Trans. Root (f	R) & Face (F)	Long. Root	& Face	Results	
_	T-011419-45-R1-	Figure QW-462.3 (a)	10		Acceptable	
	T-011419-45-R2-	Figure QW-462.3 (a)			Acceptable	
	T-011419-45-F1-	Figure QW-462.3 (a)			Acceptable	
	T-011419-45-F2-	Figure QW-462.3 (a)	13011	ne monominu	Acceptable	
Radiographic Test Resu	its:	None				
Visual Examination Res	and A star and a last	le Root: Accep	table			
Welding Test Conducter		iuillermo Castro, LIII				
Mechanical Tests Cond	- Million	uren Inspection Servic	es Lal	ooratory Test	No. PAUT02162	
We certify that the state	ements in this record a uirements of ASME Sec Petro Industrial S	tion, IX/2013	he test coupons	were prepar	ed, welded, teste	
	12/1/11	/-	Date:	02/19/2021		
By:	0 11111 11 1					

					-	
Welder's Name	George Rodrigu	Jeż	ID. #	6471	Stamp# JR (1	
WPS No.		PISL-GTAW-S	S			
Welding Process(es)		sten Arc Welding (GT	(WA	Туре	Manual	
Base Material(s)	SA-106 Gr. B	То	SA-106 Gr. B	•	Thickness 0.147"	
Manual or Semi-Automa	atic Variables for Each	Process	Actual Val	ues	Range Qualified	
Backing			F6- Withou	t	F6-With/Without	
ASME P-No. To P-No	3		P1 to P1		P1 to P15E	
Plate X Pipe (ente	r diameter, if pipe)	Root/Fill	1/2"		/2" NPS Minimum	
	ICEAL CHARLES	KOOSTIII	5.18		5.18	
Filler Metal Specification	(SFA) Classification —		-		: +·"	
mara book book book and book a		RootFill	6		6	
Filler Metal Group No	***		*			
Filler Metal Product Form	1		Solid Rod		Solid Rod	
Consumable Insert for G			None		None	
		F 6	0.147"		0.294" Maximum	
Weld Deposit Thickness		- ·	181		-	
Welding Position		The state of the s	6G (Three Cou	pon)*	All	
Maximum Deposition Rai	te		N/A			
Welding Progression (Up	hill/ Downhill)———		Uphill	Uphill		
Backing Gas for GTAW, I			None		With/ Without Argon	
GMAW Transfer Mode —			N/A		N/A	
FCAW/ GTAW Welding C			DC/ EN		DC/EN	
*Remarks: * Total weld le						
Guide Bend Test Res	rulte					
- Side	X Trans. Root (R	1) & Face (F)	Long. Root	& Face	Results	
-		Figure QW-462.3 (a)	1		Acceptable	
	T-011419-10-R2-F	Figure QW-462.3 (a)			Acceptable	
		Figure QW-462.3 (a)		1	Acceptable	
		Figure QW-462.3 (a)			Acceptable	
Radiographic Test Resul	ts:	None				
Visual Examination Resu	- Assessments	Root: Accept	table			
Welding Test Conducted		uillermo Castro, LIII				
Mechanical Tests Condu	A	ren Inspection Service	es La	boratory Test	No. PAUT021621-J	
We certify that the state accordance with the requ	ments in this record an					
O	Petro Industrial Sp	dutions, LLC				
Organization:						
By:	Mill	/	Date:	02/19/2021		

Welder's Name	Fernando Lebron		ID. # 2151	Stamp # FL (52)
WPS No.		PISL-GTAW-SS	3	
Welding Process(es)	Gas Tungs	ten Arc Welding (GT/	AW)	Type Manual
Base Material(s)	SA-106 Gr. B	То	SA-106 Gr. B	Thickness 0.147"
Manual or Semi-Automa	atic Variables for Each	Process	Actual Values	Range Qualified
Backing	and the state of t		F6- Without	F6-With/Without
ASME P-No. To P-No), <u></u>		P1 to P1	P1 to P15E
Plate X Pipe (ente	r diameter, if pipe)	Root/Fill	1/2"	1/2" NPS Minimum
PARK - 1 - 1 - 2 - 1 -	open as the materials	ROODFIN	5.18	5.18
Filler Metal Specification	(SFA) Classification —	<u> </u>	-	-
Filler Metal Group No		RootFill	6	6
riller metal Group No	111/00/00=40=5			
Filler Metal Product Form	1		Solid Rod	Solid Rod
Consumable Insert for G	TAW or PAW		None	None
ARA, E O CONT TA MANA A . A		F 6	0.147"	0.294" Maximum
Weld Deposit Thickness	: -1.51 	-	¥1	+
Welding Position			6G (Three Coupon)*	All
Maximum Deposition Rat	te		N/A	
Welding Progression (Up	shill/ Downhill)		Uphill	Uphill
Backing Gas for GTAW, I			None	With/ Without Argon
GMAW Transfer Mode —			N/A	N/A
FCAW/ GTAW Welding C	urrent Type/ Polarity		DC/ EN	DC/EN
*Remarks: * Total weld ler	ngth: 7.95"		and the second second	
Guide Bend Test Res	a sellem			
- Side	X Trans. Root (R)	& Face (F)	Long. Root & Face	Results
Į Joine		igure QW-462.3 (a)	Long, Hoot & Face	Acceptable
		gure QW-462.3 (a)		Acceptable
-		gure QW-462.3 (a)		Acceptable
		gure QW-462.3 (a)	WATER 12	Acceptable
Radiographic Test Resul		None		
Visual Examination Resu	A same a la l		abl e	
Welding Test Conducted	1563.	illermo Castro, LIII		
Mechanical Tests Condi	ucted By: Acur	en Inspection Service	s Laborator	Test No. PAUT033021-FL
We certify that the state	ements in this record are ulrements of ASME Secti	on IX/2013	ne test coupons were	prepared, welded, tested in
	Petro Industrial So	JUHONS, LLC Les	1	
Organization:	Fedo modernal ov	1537A	/	
Organization:	Caro modestrar co	MA	Date: 04/0	1/2021

Welder's Name	Jonathan Rodrig	Jonathan Rodriguez		Stamp # JR2 (49)
WPS No.	Jonathan Rodriguez ID. # 7148 PISL-GTAW-SS			
Welding Process(es)	Gas Tungsten Arc Welding (GTAW)			Type Manual
Base Material(s)	SA-106 Gr. B.	To	SA-106 Gr. B	Thickness 0.147"
Manual or Semi-Autom	atic Variables for Each	Process	Actual Values	Range Qualified
Backing			F6- Without	F6-With/Without
ASME P-No. To P-No	L		P1 to P1	P1 to P15E
Plate X Pipe (ente	r diameter, if pipe)		1/2"	1/2" NPS Minimum
Filler Metal Specification (SFA) Classification — Filler Metal Group No.		RootFill —	5.18	5.18
		RooVFill	6	6
riiier wetai Group No			= :	-
Filler Metal Product Form			Solid Rod	Solid Rod
Consumable Insert for GTAW or PAW			None	None
		F 6	0.147"	0.294" Maximum
Weld Deposit Thickness	Value of the second of the sec		V <u>2</u>	-
Welding Position	-0		6G (Three Coupon)*	All
Maximum Deposition Rat	te	_	N/A	
Welding Progression (Up	hill/ Downhill)		Uphill	— Uphill
Backing Gas for GTAW, PAW, GMAW or FCAW/G			None	With/ Without Argon
GMAW Transfer Mode			N/A	N/A
FCAW/ GTAW Welding Current Type/ Polarity			DC/ EN	DC/EN
*Remarks: * Total weld le	5.7			
THE WAY THE STATE OF THE STATE	and the same of th		a manusa mini halisi	
Guide Bend Test Res		5 . Ph. 1987		
- Side	X Trans. Root (R)		Long. Root & Face	Results
		T-052918-49-R1-Figure QW-462.3 (a)		Acceptable
		T-052918-49-R2-Figure QW-462.3 (a)		Acceptable
- T-052918-49-F		igure QW-462.3 (a)		Acceptable
	T-052918-49-F2-F	igure QW-462.3 (a)		Acceptable
Radiographic Test Resul		None		
Visual Examination Resu	Its: Face: Acceptable	Root: Accep	otable	
Welding Test Conducted	By: Gu	illermo Castro, LIII		
Mechanical Tests Condu	icted By: Acur	en Inspection Servi	ces Laboratory	Test No. PAUT033021-JR2
We certify that the state accordance with the requ	irements of ASME Secti	on IX/2013	the test coupons were p	repared, welded, tested in
Organization:	Petro Industrial So	lutions, LLC		
Ву:	Adrian Melendez Jr.; PM			2021
	Author Indez Jr	-, □ 1VE		

Welder's Name	Richael Philips		ID.# 479	99 Stamp # RP (5
WPS No.		PISL-GTAW-S	S	
Welding Process(es)	Gas Tungs	sten Arc Welding (GT	AW)	Type Manual
Base Material(s)	SA-106 Gr. B	То	SA-106 Gr. B	Thickness 0.147"
Manual or Semi-Automatic Variables for Each Process			Actual Values	Range Qualified
Backing			F6- Without	F6-With/Without
ASME P-No. To P-No.			P1 to P1	P1 to P15E
Plate X Pipe (enter	diameter, if pipe)		1/2"	1/2" NPS Minimum
		RootFill	5.18	5,18
Filler Metal Specification (SFA) Classification —			*	
Filler bilatel Croup No.		Root/Fill	6	6
Filler Metal Group No.			*	4
Filler Metal Product Form			Solid Rod	Solid Rod
Consumable insert for GTAW or PAW			None	None
		F 5	0.147"	0.294" Maximum
Weld Deposit Thickness -		-		16
Welding Position			6G (Three Coupon)*	All
Maximum Deposition Rate			N/A	
Welding Progression (Uphill/ Downhill)			Uphill	Uphill
Backing Gas for GTAW, PAW, GMAW or FCAW/G			None	With/ Without Argon
GMAW Transfer Mode —			N/A	N/A
FCAW/ GTAW Welding Current Type/ Polarity			DC/ EN	DC/EN
*Remarks: * Total weld leng	gth: 7.91"			
C. 11- D 1 T 4 D	-th-			
Guide Bend Test Resu - Side	X Trans. Root (R)	2 Enon (E)	7	Ph
- Joina			Long. Root & Face	
	_	T-082118-51-R1-Figure QW-462.3 (a)		Acceptable
	T-082118-51-R2-Figure QW-462.3 (a)			Acceptable
•				
•	T-082118-51-F1-F	gure QW-462.3 (a)		Acceptable
-	T-082118-51-F1-F1 T-082118-51-F2-F	gure QW-462.3 (a) gure QW-462.3 (a)		
	T-082118-51-F1-Fi T-082118-51-F2-Fi	gure QW-462.3 (a) gure QW-462.3 (a) None	-11	Acceptable
Visual Examination Result	T-082118-51-F1-Fi T-082118-51-F2-Fi :: :: :: Acceptable	gure QW-462.3 (a) gure QW-462.3 (a) None Root: Accept	able	Acceptable
Visual Examination Result	T-082118-51-F1-Fi T-082118-51-F2-Fi s: Face: Acceptable Gu	gure QW-462.3 (a) gure QW-462.3 (a) None Root: Accept		Acceptable
Visual Examination Result Welding Test Conducted E	T-082118-51-F1-Fi T-082118-51-F2-Fi s: Face: Acceptable Gu	gure QW-462.3 (a) gure QW-462.3 (a) None Root: Accept		Acceptable
Visual Examination Result Welding Test Conducted E Mechanical Tests Conduc We certify that the statem accordance with the require	T-082118-51-F1-Fi T-082118-51-F2-Fi is: Face: Acceptable Gu sted By: Acur nents in this record are	gure QW-462.3 (a) gure QW-462.3 (a) None Root: Accept Illermo Castro, LIII en Inspection Service correct and that ti on IX/2013	s Laborator	Acceptable Acceptable
Radiographic Test Results Visual Examination Result Welding Test Conducted E Mechanical Tests Conduc We certify that the statem accordance with the requir Organization: By:	T-082118-51-F1-Fi T-082118-51-F2-Fi is: Face: Acceptable By: Gu ted By: Acur nents in this record are rements of ASME Section	gure QW-462.3 (a) gure QW-462.3 (a) None Root: Accept Illermo Castro, LIII en Inspection Service correct and that ti on IX/2013	Laborator Laborator vere	Acceptable Acceptable Y Test No. PAUT031721-RF

Adrian Melendez

From:

David Smith <dsm@vtti.com>

Sent:

Wednesday, July 28, 2021 8:00 AM

To:

Adrian Melendez

Cc:

Chad Persaud; Merlin Figueira; Terence Keogh; Andreas Constantinou

Subject:

RE: Testing requirements

Good morning Adrian,

We have some calls this morning, but will be able to review and respond later today.

Regards,

From: Adrian Melendez <adrian@petroindustrial.us>

Sent: Tuesday, July 27, 2021 10:18 PM To: David Smith <dsm@vtti.com>

Cc: Chad Persaud <chad@petroindustrial.us>; Merlin Figueira <mef@vtti.com>; Terence Keogh <tek@vtti.com>;

Andreas Constantinou <aco@vtti.com>
Subject: RE: Testing requirements

Good evening Gent,

Please find our response to your comments below:

- In the place of the ITP and daily records, can you please share the internal welding procedures you applied for GT 17 and GT 20? I assume these procedures are approved by an ASME Authorized Inspection Agency? Petro's welding procedures were created and approved in 2018 by INI Corp out of Puerto Rico under Section IX of the ASME code. INI Corp is an approved ASME ASMT approved company for WPS and Inspections. Petro has use and have continued to test through numerous PAUT & X-ray these same procedures at Limetree Bay. IPOS Diageo, and Cruzan Rum since 2018.
- Related to the PAUT report, you signed the qualification certificate on behalf of Acuren/Costas. We
 believe that there must be a report/certificate/document from Acuren/Costas in order for you sign the
 WPQ. Can you please provide? <u>Please see Mr. Castro's attached letter regarding this question.</u>

Thank you,

Adrian Melender Project Manager (956) 605-4142

From: David Smith <dsm@vtti.com>
Sent: Tuesday, July 27, 2021 8:46 AM

To: Adrian Melendez <adrian@petroindustrial.us>

Cc: Chad Persaud <chad@petroindustrial.us>; Merlin Figueira <mef@vtti.com>; Terence Keogh <tek@vtti.com>;

Andreas Constantinou <aco@vtti.com>

Subject: RE: Testing requirements

Good morning Adrian,

Two comments from us.

EXHIBIT & ST.

PIS000061

1

- In the place of the ITP and daily records, can you please share the internal welding procedures you
 applied for GT 17 and GT 20? I assume these procedures are approved by an ASME Authorized Inspection
 Agency?
- Related to the PAUT report, you signed the qualification certificate on behalf of Acuren/Costas. We believe that there must be a report/certificate/document from Acuren/Costas in order for you sign the WPQ. Can you please provide?

We are trying to work through this and I believe we all recognize that time is off the essence.

Regards,

David

From: Adrian Melendez <adrian@petroindustrial.us>

Sent: Monday, July 26, 2021 11:30 PM
To: David Smith < dsm@vtti.com>

Cc: Chad Persaud <chad@petroindustrial.us>; Merlin Figueira <mef@vttl.com>; Terence Keogh <tek@vttl.com>;

Andreas Constantinou <aco@vtti.com>
Subject: Re: Testing requirements

Good evening, please find our response below along side your questions:

- Full inspection and test plan no I&TP reports were required from IPOS/Vitol and and therefore none can be provided.
- Daily records (for welding, fitting, visual inspection) we do not have daily reports but have included weld logs with all NDT which includes VT on all welds from a third party inspection company.
- Welding and mechanical tests of WPQs The actual welders' qualification certificate ware given to Petro in lieu of a PAUT report. Each Welder was tested on four different positioned coupons which were phase array inspected and passed. Certification were then approved, accepted and signed by Petro.

All welders could be re-qualified under IPOS/VTTI supervision via X-ray or PAUT if need be.

Thank you

Adrian Melendez Project Manager

956-605-4142

On Jul 26, 2021, at 7:23 AM, David Smith <dsm@vttl.com> wrote:

Good morning Adrian,

Here is what Andreas is looking for.

Hello David, in regards to the list of documents missing:

- Full inspection and test plan
- Daily records (for welding, fitting, visual inspection)
- Welding and mechanical tests of WPQs

Please let us know if you have any questions.

Regards,

David

From: David Smith

Sent: Friday, July 23, 2021 10:19 AM

To: Adrian Melendez <adrian@petroindustrial.us>

Cc: Chad Persaud <chad@petroIndustrial.us>; Merlin Figueira <mef@vtti.com>; Terence Keogh

<tek@vtti.com>; Andreas Constantinou <aco@vtti.com>

Subject: RE: Testing requirements

Good morning Adrian,

Andreas has been reviewing the documentation and is looking for some more specific information.

He will be sending me a fist and we will make sure you have it.

Regards,

David

From: Adrian Melendez <adrian@petroindustrial.us>

Sent: Thursday, July 22, 2021 4:25 PM
To: David Smith <dsm@vtti.com>

Cc: Chad Persaud chad@petroindustrial.us; Merlin Figueira mef@vtti.com; Terence Keogh

<tek@vtti.com>; Andreas Constantinou <aco@vtti.com>

Subject: Re: Testing requirements

Done, Thanks David

Adrian Melendez Project Manager

956-605-4142

On Jul 22, 2021, at 4:23 PM, David Smith < dsm@vtti.com > wrote:

Hi Adrian,

Can you add me? I never got it either.

Regards.

From: Adrian Melendez <adrian@petroindustrial.us>

Sent: Thursday, July 22, 2021 4:23 PM To: David Smith characteristics

Cc: Chad Persaud < chad@petroindustrial.us>; Merlin Figueira < mef@vtti.com>; Terence

Keogh <tek@vtti.com>; Andreas Constantinou <aco@vtti.com>

Subject: Re: Testing requirements

Hi David,

I just shared the 3" vent folder on Dropbox with Andreas. Andreas, most of what your asking for is in the folder. Please let me know if anything else is needed.

Thank you,

Adrian Melendez Project Manager

956-605-4142

On Jul 22, 2021, at 4:13 PM, David Smith <dsm@vtti.com> wrote:

Adrian.

Sorry, I should have been clearer.

Andreas is our Global Technical Director. He had helped with this. If some of it is in the dropbox you provided to Vitol last week, can you please add Andreas and I? This is what he is looking for. I added him, so you can ask any questions.

Regards, David

- Approved Welding Procedures (stamped by third party would be my recommendation – Notified Body in Europe – where ASME is followed the equivalent is Authorised Inspection Agency I think)
 - Welding procedures to be representative of the work that would be carried out
- Submit Quality control documentation that they plan to follow during the project
 - o Inspection and Test Plan (ITP)
 - o Material certificates and traceability records
 - Daily records (for welding, fitting, visual inspection, pressure test etc)
 - Welding maps and welding monitoring and finished welding records
 - Any internal inspections carried out (separate to the third party ones) – see previous to last builtet point
 - Record and Certificates for consumables (gases, electrodes etc)

- Documentation of Welding procedures utilised in the project and valid welder certificates for anyone on the site
- NDT reports received from third party
- Pressure testing report

With regards to the completed project, I would expect to see the items listed in the above second bullet point. Basically, you should be able to trace all the details of a particular weld

- 1) What parent material was used
- Which procedure was followed for the welding and what consumables were used
- 3) Who welded it and when
- 4) Who checked the fitting and who checked the weld visually
- If it was NDT, by which method, when and what was the result (records)
- 6) If it was pressure tested and when (records)

From: Adrian Melendez <adrian@petroindustrial.us>

Sent: Thursday, July 22, 2021 2:43 PM

To: David Smith < dsm@vtti.com >; Chad Persaud

<chad@petroindustrial.us>

Cc: Merlin Figueira <mef@vtti.com>; Terence Keogh <tek@vtti.com>

Subject: RE: Testing requirements

Hi David,

I have attached the welders' quals for your review. Let me know what else I can provide and when we can meet with the inspector Guillermo for clarification.

Thank you,

Adrian Melendez Project Manager (956) 605-4142

From: David Smith < dsm@vtti.com>
Sent: Thursday, July 22, 2021 12:17 PM

To: Chad Persaud <chad@petroindustrial.us>; Adrian Melendez

<adrian@petroindustrial.us>

Cc: Merlin Figueira <mef@vtti.com>; Terence Keogh <tek@vtti.com>

Subject: Testing requirements

Chad and Adrian,

Before we speak to Guillermo, we would like to have all of the testing records.

If you can please provide them, we will review and then be prepared to speak to Guillermo.

If you have any questions please let us know.

Regards.

David

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July 29, 2021

To: Petro Industrial

My name is Guillermo Castro and I am an independent contractor with my own business that approves and test welds for different independent clients.

Recently I worked in Puerto Rico from January to May 2021 for an independent client. Adrian Melendez from Petro Industrial contact me to test & qualify a few welders that I personally qualified three years ago at Limetree Bay. I tested six welders for Adrian, at my Client's shop in Puerto Rico, but unfortunately did not have the original Quals under Acuren saved and to re-certify the previous reports I had to adjust the old welders' quals and changed the welders' tensile number, the qualification date, and the four test coupons. I gave Petro Industrial a welder's qualification certificate for each welder, which all welders passed, in lieu of a PAUT report. No qualification reports were created due to each welder was just testing to re-qualify. Should you need me to come to St. Croix to recertify the welders I'm willing to do so.

On another note, I will be leaving on a project overseas and will have very limited internet access. Please use this letter as my communication on this matter.

Regards,

Guillermo Castro gcastrod0@gmail.com





July 28, 2021

VIA ELECTRONIC MAIL AND US MAIL

Petro Industrial Solutions LLC c/o Adrian Melendez, President P.O. Box 26303 Christiansted, St. Croix U.S. Virgin Islands 00824

Re: Maintenance Contract dated September 1, 2019

Dear Mr. Melendez,

Pursuant to paragraph 6 of the above noted contract, this will serve to provide notice of termination of the contract between Island Project and Operating Services LLC ("IPOS") and Petro Industrial Solutions LLC.

Sincerely,

David Smith General Manager

IPOS II.C P.O. Box 303388 St. Thomas, VI 008 03 US Virgin Islands W: www.vtti.com

